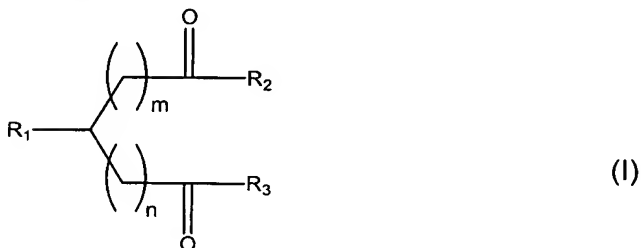


**CLAIMS**

1. A process for the production of a fuel composition having a NACE corrosion rating of between 0% and 25%, comprising the steps of:

- 5 (i) contacting a fuel with a corrosion inhibitor of formula (I) to provide an initial fuel composition



wherein m and n are each independently an integer from 0 to 10;

wherein R<sub>1</sub> is an optionally substituted hydrocarbyl group;

wherein

- 10 either R<sub>2</sub> is OR<sub>4</sub> and R<sub>3</sub> is OR<sub>5</sub>, wherein R<sub>4</sub> and R<sub>5</sub> are selected from hydrogen and hydrocarbyl-OH and wherein at least one of R<sub>4</sub> and R<sub>5</sub> is hydrogen;  
or R<sub>2</sub> and R<sub>3</sub> together represent —O—;  
and

- (ii) contacting the initial fuel composition with a caustic material to provide the fuel  
15 composition without subsequent addition of a corrosion inhibitor.

2. A process according to claim 1 wherein m and n are each independently an integer from 0 to 5.

- 20 3. A process according to claim 1 or 2 wherein one of m and n is 0 and the other of m and n is 1.

4. A process according to claim 1, 2 or 3 wherein R<sub>1</sub> is an optionally substituted hydrocarbon group.

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5. A process according to any one of the preceding claims wherein R<sub>1</sub> is an optionally substituted alkyl or alkenyl group.

6. A process according to any one of the preceding claims wherein R<sub>1</sub> is an optionally  
30 substituted branched alkyl or alkenyl group.

7. A process according to any one of the preceding claims wherein  $R_1$  is a polyisobutenyl group.

5 8. A process according to any one of the preceding claims wherein  $R_1$  has between 10 and 200 carbon atoms.

9. A process according to any one of the preceding claims wherein  $R_1$  has between 12 and 32 carbon atoms.

10

10. A process according to any one of the preceding claims wherein  $R_1$  has a molecular weight of from 250 to 400.

11. A process according to any one of the preceding claims wherein  $R_1$  has a molecular  
15 weight of approximately 260 or approximately 360.

12. A process according to any one of the preceding claims wherein  $R_2$  is  $OR_4$  and  $R_3$  is  $OR_5$ .

20 13. A process according to any one of the preceding claims wherein  $R_4$  and  $R_5$  are selected from hydrogen and  $(C_xH_{2x})-OH$  wherein  $x$  is an integer of at least 1.

14. A process according to any one of the preceding claims wherein  $R_4$  and  $R_5$  are selected from hydrogen and  $(CH_2)_y-OH$  wherein  $y$  is an integer of at least 1.

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15. A process according to any one of the preceding claims wherein  $R_4$  and  $R_5$  are both hydrogen.

16. A process according to any one of the preceding claims wherein one of  $m$  and  $n$  is 0  
30 and the other of  $m$  and  $n$  is 1,  $R_1$  is a polyisobutenyl group with a molecular weight of approximately 260 or 360,  $R_2$  is  $OR_4$ ,  $R_3$  is  $OR_5$  and  $R_4$  and  $R_5$  are both hydrogen.

17. A process according to any one of the preceding claims wherein, in step (i), the fuel is treated with 1 to 20 ptb of a corrosion inhibitor of formula (I).

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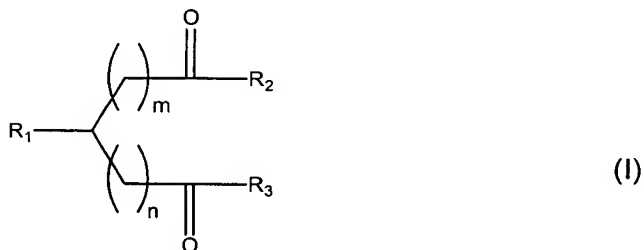
19. A process according to any one of the preceding claims wherein, in step (ii), the  
5 caustic material is an alkaline solution.

10 21. A process according to any one of the preceding claims wherein, in step (ii), the caustic material is a 1% - 10% w/w alkaline solution.

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24. A fuel composition obtained or obtainable by a process according to any one of the  
20 preceding claims.

(i) contacting the fuel with a corrosion inhibitor of formula (I) to provide an initial fuel composition



wherein

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or R<sub>2</sub> and R<sub>3</sub> together represent —O—;

(ii) contacting the initial fuel composition with a caustic material to provide a fuel composition; and

(iii) exposing the metal surface to the fuel composition.

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26. A method according to claim 25 wherein the corrosion inhibitor of formula (I) is as defined in any one of claims 2 to 16 and/or step (i) is as defined in either of claims 17 or 18 and/or step (ii) is as defined in any one of claims 19 to 23.

10 27. Use of a corrosion inhibitor of formula (I) as defined in any one of claims 1 to 16 for providing caustic wash resistant corrosion inhibition.

28. A process substantially as hereinbefore described with reference to the Examples.

15 29. A fuel composition substantially as hereinbefore described with reference to the Examples.

30. A method substantially as hereinbefore described with reference to the Examples.

20 31. Use substantially as hereinbefore described with reference to the Examples.